

Date: Friday, 7/4/2008 12:50:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 40302	
Estimate Number : 10693	
P.O. Number :	Part Number : D32995
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D3299 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 23303	Material :
Written By : <u>JA</u>	Due Date : 7/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JA 08 07.07</u>	
Comment : Est: A 04.10.04 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H1625	6061T6 hex bar 1.625
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Comment: Qty.: 0.2013 f(s)/Unit Total : 0.8051 f(s)

6061T6 hex bar 1.625

Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex

(M6061T6H1.625)

Identify as D3299-5

Batch: M17625J.F. 08/07/14 (4)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Cut blank: 2.950" long

Turn as per Folio FA465 and Dwg D3299

J.F. 08/07/14 (4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/07/14 (4)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L. 08/07/31

5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
-----	-----------------	-----------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 6865

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

CD 08/08/10 5(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:50:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 40302

Part Number: D32995

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

CL 8/08/18

(4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CL 8/08/18 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(4x)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker,
then Stock

Location: 83

8/8/18

SC

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/2018

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40302
Description: Fitting		Part Number:	D3299-5
Inspection Dwg: D3299	Rev: B1	08.07.07	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

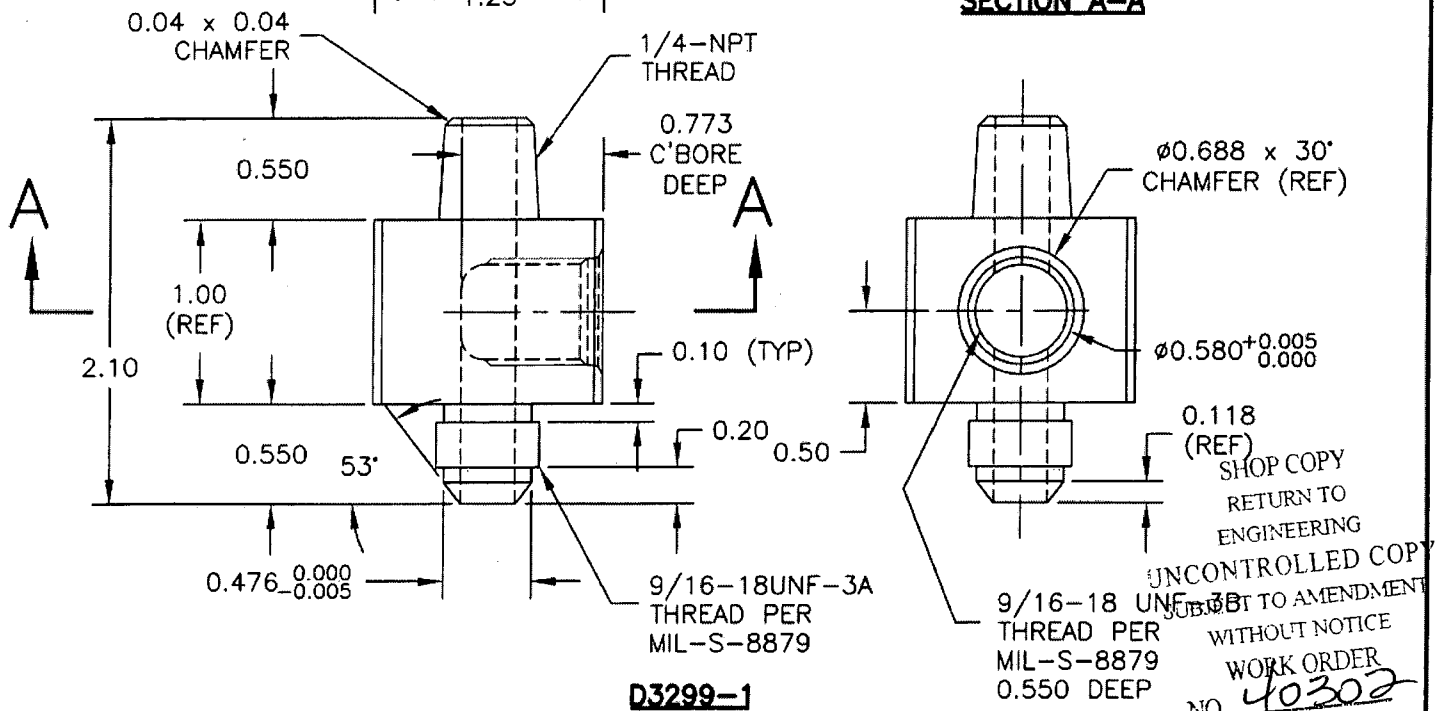
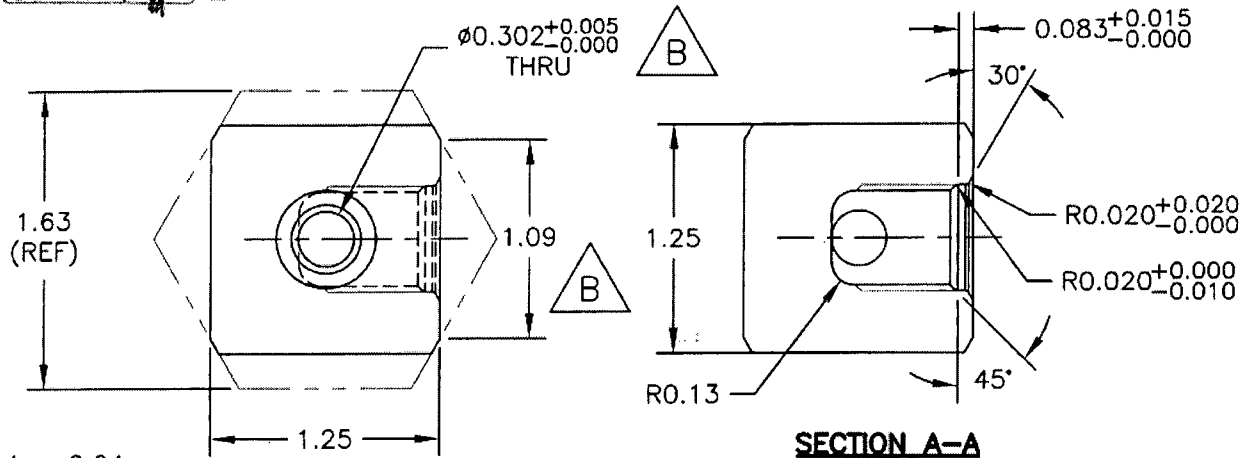
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.625	+/-0.010	1.625"	✓			
1.250	+/-0.010	1.251	✓			
Ø1.00	+/-0.030	.999"	✓			
Ø0.560	+0.005/-0.000	Ø.560	✓			
Ø0.302	+0.005/-0.000	Ø.306"	✓			
0.083	+0.015/-0.000	.084	✓			
30°	+/-0.5°	30°	✓			
53°	+/-0.5°	53°	✓			
1.00	+/-0.030	1.005"	✓			
1.700	+/-0.010	1.701"	✓			
R0.06	+/-0.030	R0.060"	✓			
Ø0.476	+0.000/-0.005	Ø.476"	✓			
MOW for 9/16"-18	Max: .5742 Min: .5709 Min = 0.5709 Max = 0.5742	.574"	✓			
0.20	+/-0.030	.200"	✓			
0.93	+/-0.030	.930"	✓			
0.150	+/-0.010	.147"	✓			
Ø0.688	+/-0.010	Ø.690	✓			
Ø0.580	+0.005/-0.000	Ø.580	✓			
0.50	+/-0.030	.502	✓			
2.85	+/-0.030	2.855"	✓			

Measured by: J.F./omk	Audited by: J.L	Prototype Approval:	N/A
Date: 08/07/14	Date: 08/07/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.313	KJ/JLM	

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED
05.04.28 #**D3299-1****D3299-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

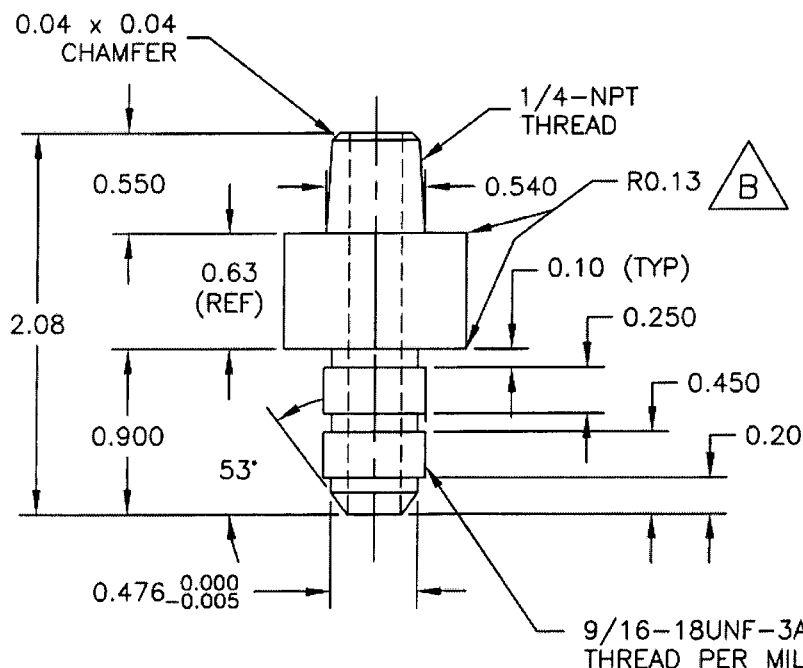
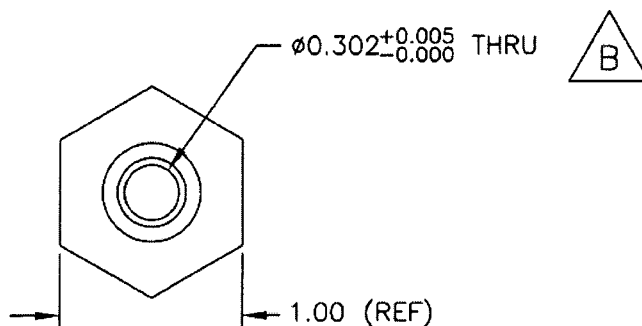
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CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED
05.04.28 #



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

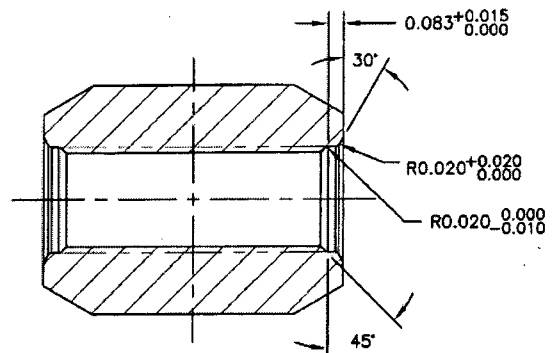
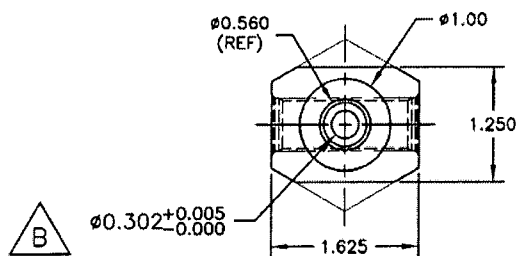
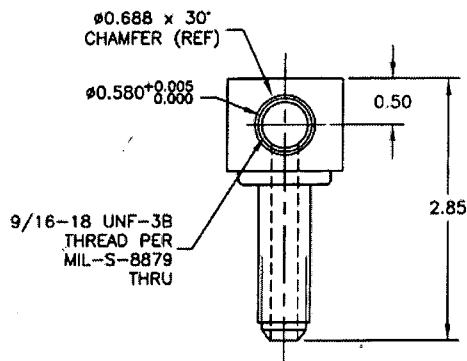
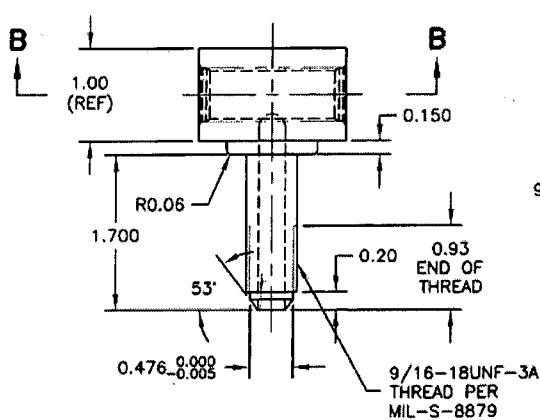
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED
05.04.28**SECTION B-B**
SCALE 1:1**D3299-5****D3299-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

67086

07-Aug-2008

CLIENT / CUSTOMER:

PART AEROSPACE LTD.

1070 ABERDEEN STREET

NEWKESBURY, ONTARIO

BA 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITENO. DE COMMANDE:
PURCHASE ORDER/

PO00006865



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	D3299-1 B40301	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
2	8	8	D3299-3 B40257	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
3	4	4	D3299-5 B40302	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

Tous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient
Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air
ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager